

**Work Order ID 67204**

Page 1

Thursday, March 10, 2011 10:23:03 AM

Item ID: D3407-043

Accept



Setup Start



Revision ID:

Item Name: Tow Ring

Stop



Start Date: 3/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/15/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

Draw Nbr	Revision Nbr
D3407	Rev E

100



Large Fab

Large Fab

Memo

0.00

0.00

E 11-3-14

X8

Large Fab

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI  
004 A/R TIG174 ROD Batch: M101972

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

P 11-3-14

Quality Control

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

S 11-3-15

Quality Control

X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3407-043

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Item Name: Tow Ring

Stop



Start Date: 3/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/15/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
StampM115951 .  
Memo

0.00

12:00 OVEN  
1:00

8 BL 11-3-08.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=7 m-f 11/03/28 (8X)

150



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 464

0.00

Memo

0.00

11/3/30 (8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 67204**

Thursday, March 10, 2011 10:23:03 AM



Page 3

Item ID: D3407-043

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Setup Start



Revision ID:

Item Name: Tow Ring

Stop



Start Date: 3/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 3/15/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160

Operation  
Description

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

QC

Quality Control

Memo

0.00

11/3/31  
MF

11-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

# Picklist Print

Thursday, March 10, 2011 10:23:01 AM

Page 1

Work Order ID: 67204



Parent Item: D3407-043



Parent Item Name: Tow Ring

Start Date: 3/10/2011

Required Date: 3/15/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 05.10.14 (New issue) JKJ/EC

IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-3 		Manufactured		No		100	Each	16.0000	1	8		 EL 11-3-14	

Stem

Location	Loc Qty	Loc Code
WA	16	
64436	16	

D3407-5

Manufactured No

Ring

Location	Loc Qty	Loc Code
WA	16	
66556	16	

EL 11-3-14

8

EL 11-3-14

8

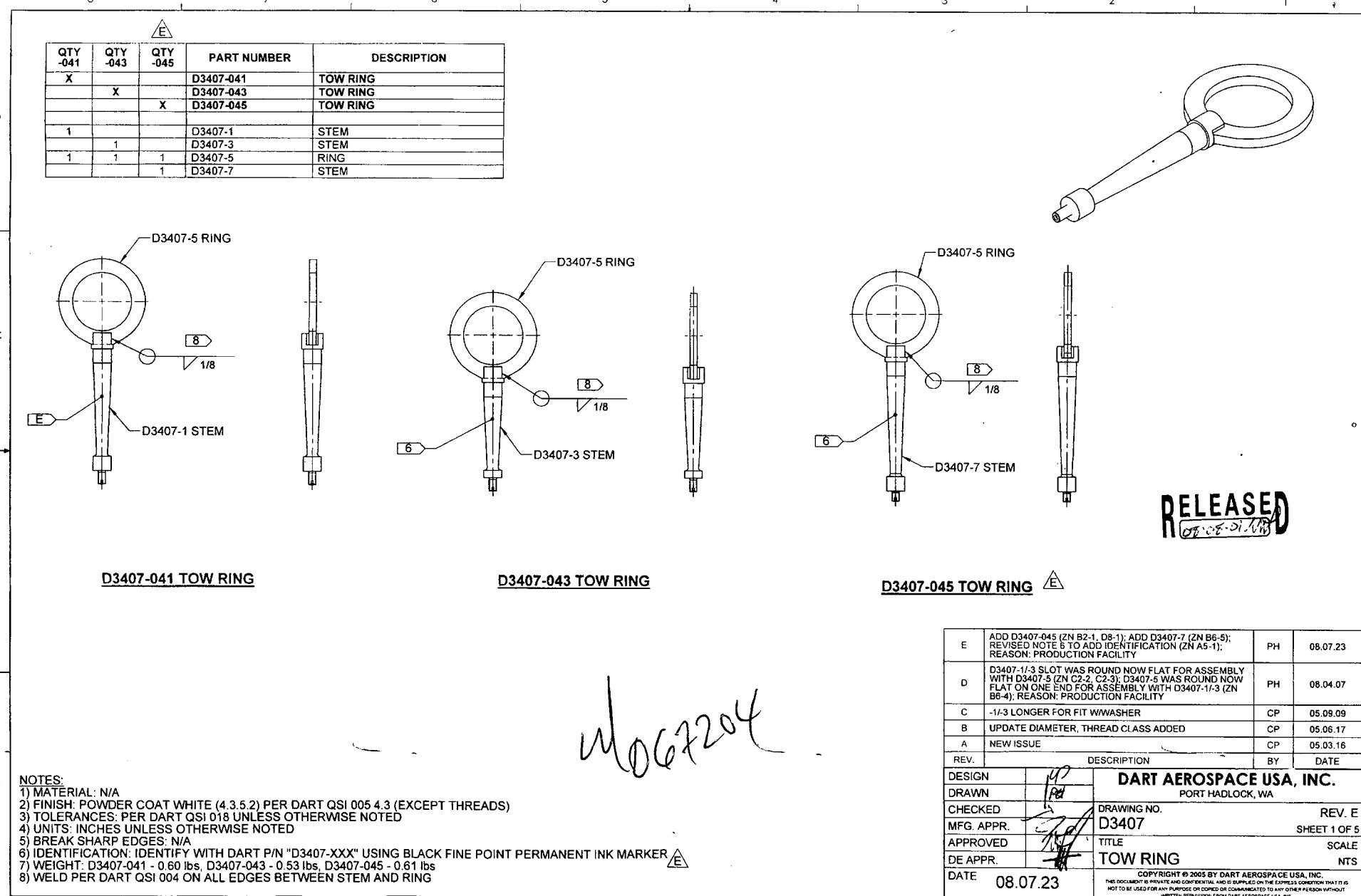
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NOTE: Date & initial all entries



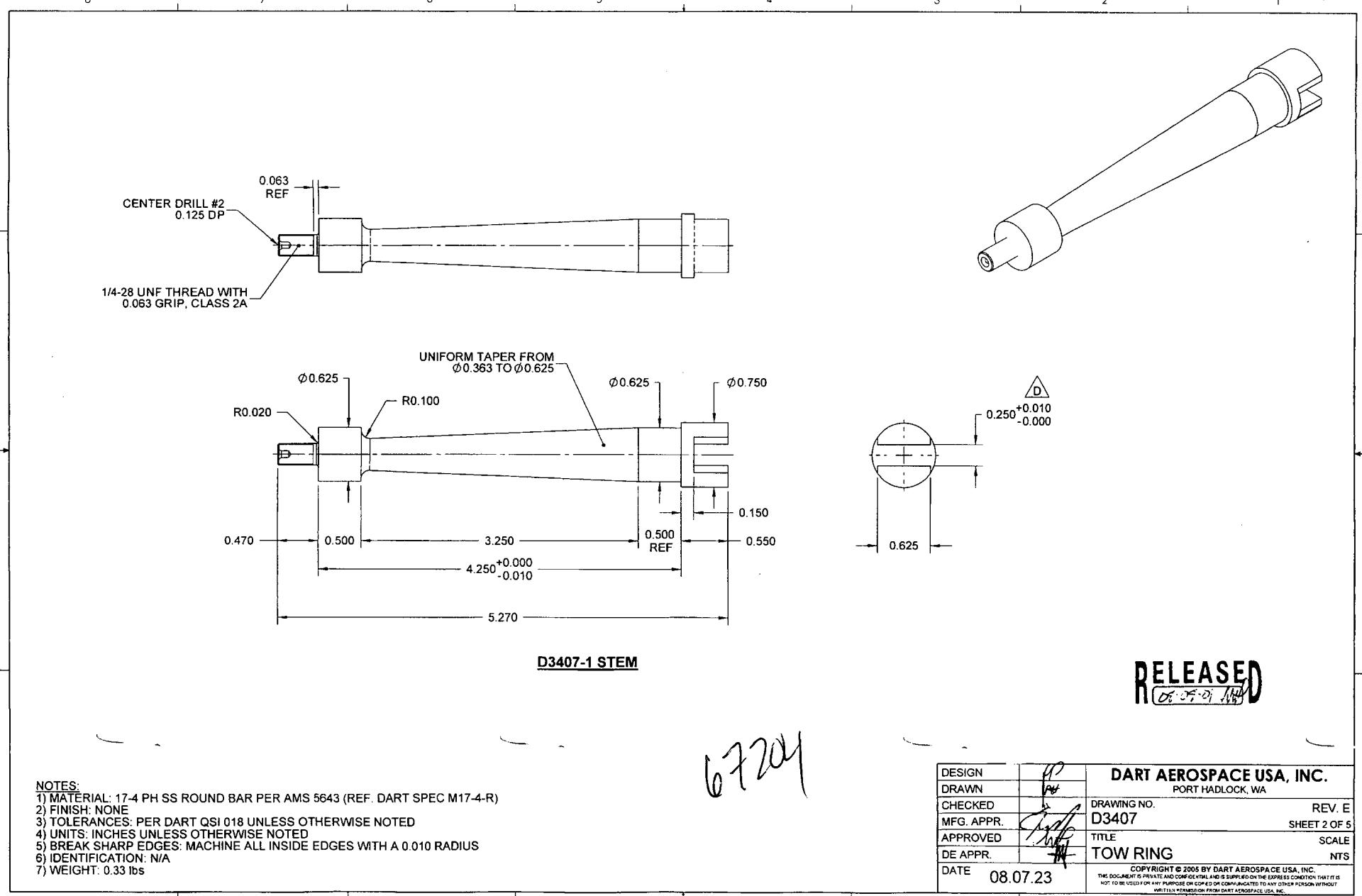
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**NOTES:**

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

67204

DESIGN	<i>fp</i>	DART AEROSPACE USA, INC.		
DRAWN	<i>fp</i>	PORT HADLOCK, WA		
CHECKED	<i>✓</i>	DRAWING NO.	REV. E	
MFG. APPR.	<i>CJH</i>	D3407	SHEET 2 OF 5	
APPROVED	<i>W.H.</i>	TITLE	SCALE	
DE APPR.	<i>W.H.</i>	TOW RING	NTS	
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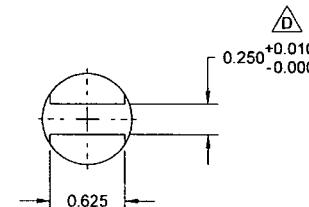
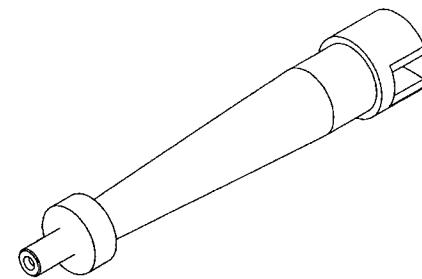
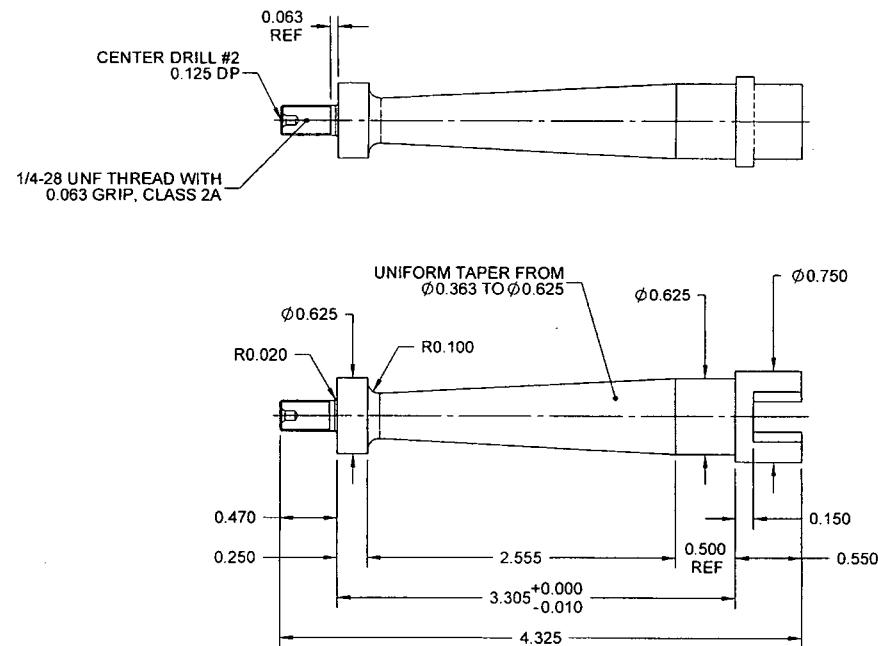
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3407-3 STEM

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

67204

DESIGN	<i>99</i>	DART AEROSPACE USA, INC.		
DRAWN	<i>104</i>	PORT HADLOCK, WA		
CHECKED	<i>S</i>	DRAWING NO.	REV. E	
MFG. APPR.	<i>J. G.</i>	D3407	SHEET 3 OF 5	
APPROVED	<i>J. M.</i>	TITLE	SCALE	
DE APPR.	<i>H</i>	TOW RING	NTS	
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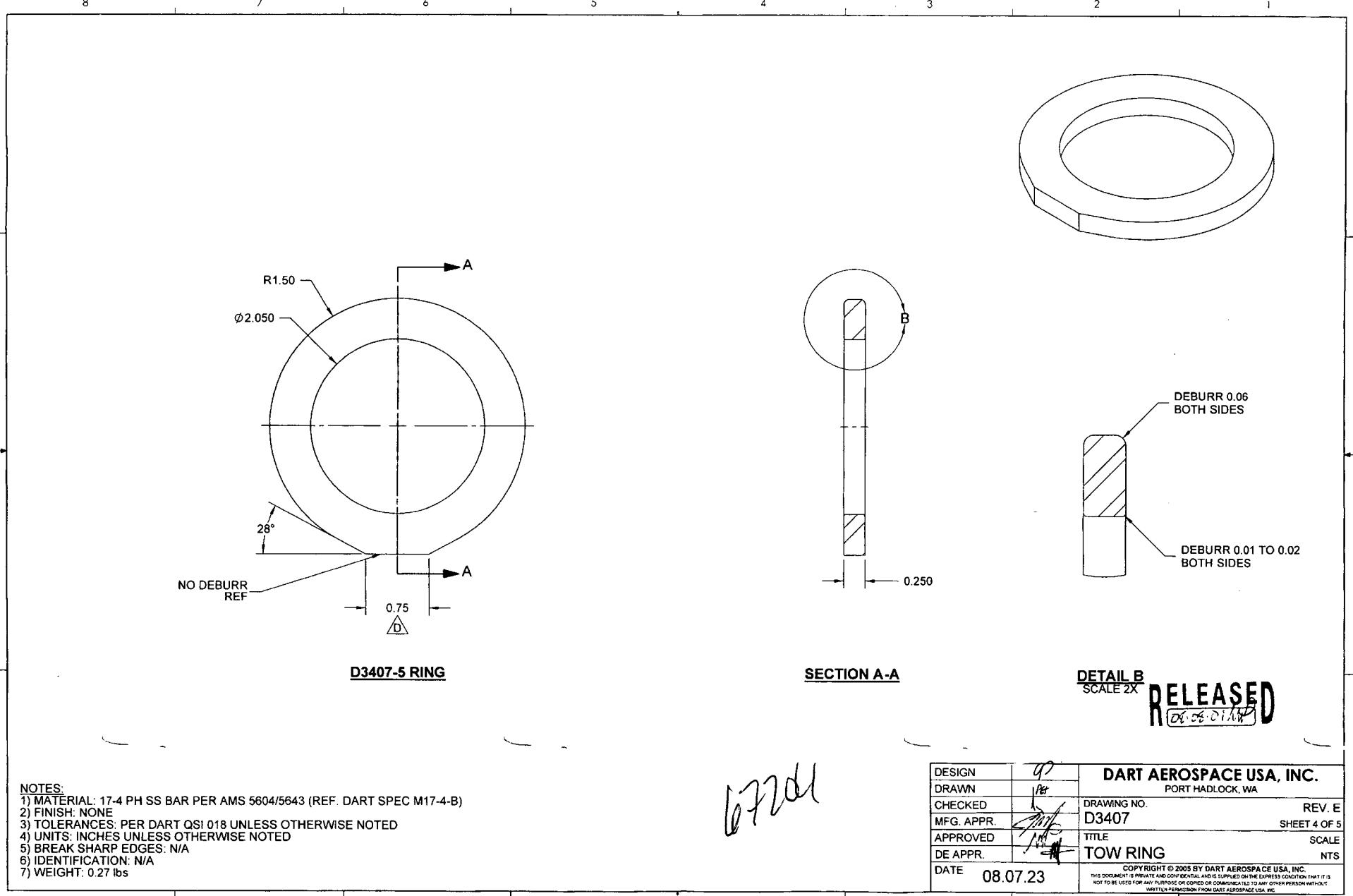
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>90</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>101</i>	PORT HADLOCK, WA	
CHECKED	<i>101</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>101</i>	D3407	SHEET 4 OF 5
APPROVED	<i>101</i>	TITLE	SCALE
DE APPR.	<i>101</i>	TOW RING	NTS
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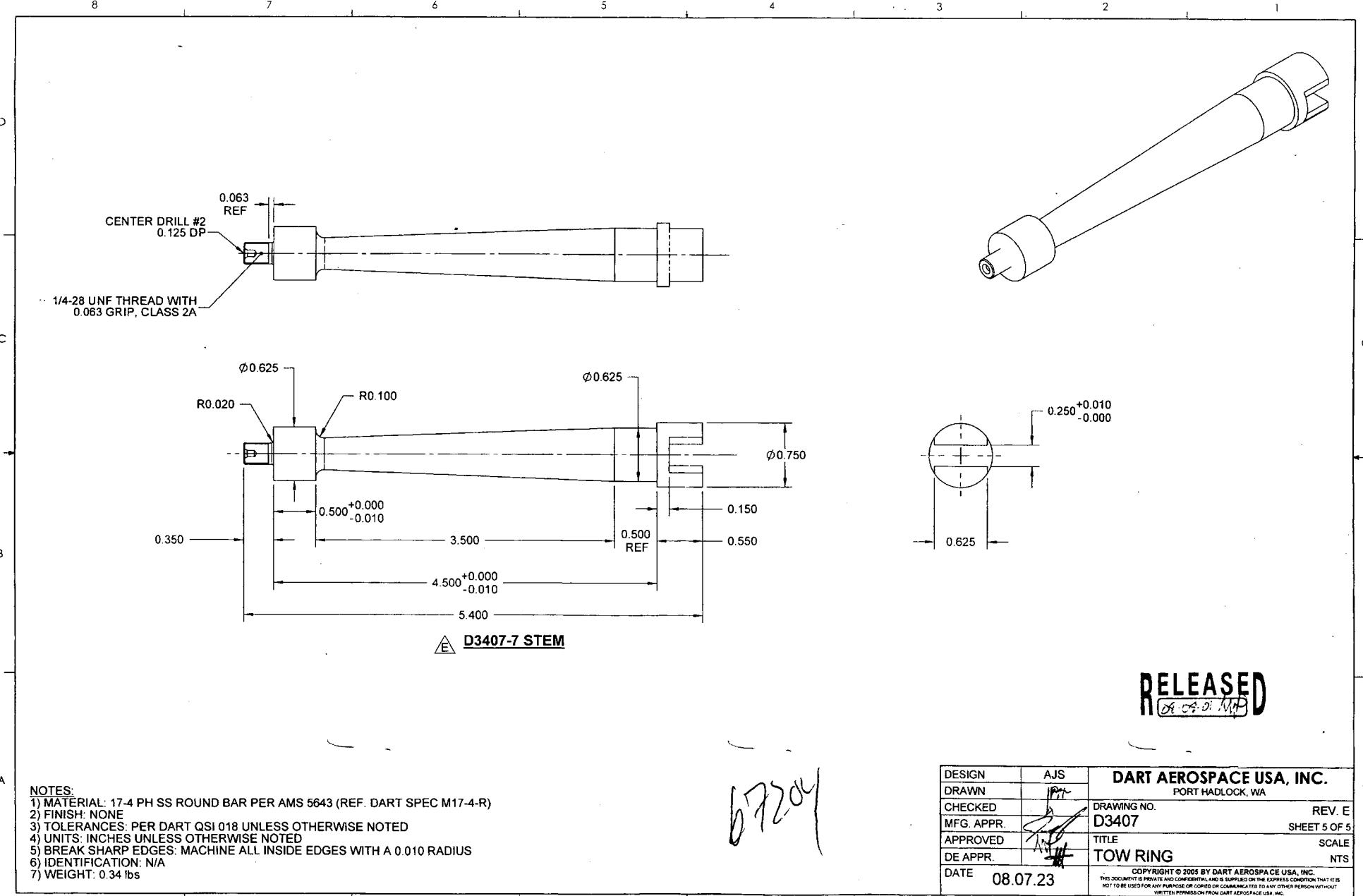
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**NOTES:**  
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4)  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.34 lbs

6720

DESIGN	AJS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E	
MFG. APPR.	<i>[Signature]</i>	D3407	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
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